

Work Order ID: 77852-2

December-22-11 8:20:20 AM

\*77852\*

Page 1

Item ID: D4092-1

Revision ID:

Item Name: Maintenance Step

Start Date: 22/12/2011 Start Qty: 10.00

Required Date: 05/01/2012 Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M.C.J.

Date: 11/12/22 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept  
Qty Reject  
Qty Reject  
Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Cut blanks as per folio

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

110

\*110\*

HAAS I

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA935

Dwg Rev

Folio rev

0.00

0.00

Deburr

# Work Order ID 77852

December-22-11 8:20:20 AM

**\*77852\***

Page 2

Item ID: D4092-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Maintenance Step

Start Date: 22/12/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

20/12/11 11:00 AM

20/12/11 11:00 AM

20/12/11

20/12/11

# Work Order ID 77852

**\*77852\***

Page 3

December-22-11 8:20:20 AM

Item ID: D4092-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Maintenance Step

Start Date: 22/12/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

155

Wing Walk as per dwg QSI005 4.4 Batch *17094* 0.00

**\*155\***

Hand Finish

Memo

0.00

Hand Finishing

*20 12-2-11*

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*20 12-2-11*

170

Identify as per dwg & Stock Location *G-A* 0.00

**\*170\***

Packaging

Memo

0.00

Packaging

*12/02/23 19*

**Work Order ID 77852****\*77852\***

Page 4

Item ID: D4092-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Maintenance Step

Start Date: 22/12/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*[Signature]* M.C.J 12/02/23

*[Signature]* 12-02-23  
(19)

# Picklist Print

December-22-11 8:20:25 AM

Page 1

Work Order ID: 77852

\*77852\*

Parent Item: D4092-1

\*D4092-1\*

Parent Item Name: Maintenance Step

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD  
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2761-108

Manufactured No

100

f

144.8438

2.5

26.31579

\*\*

\*D2761-108\*

Extrusion (HPK)

Location

Loc Qty

Loc Code

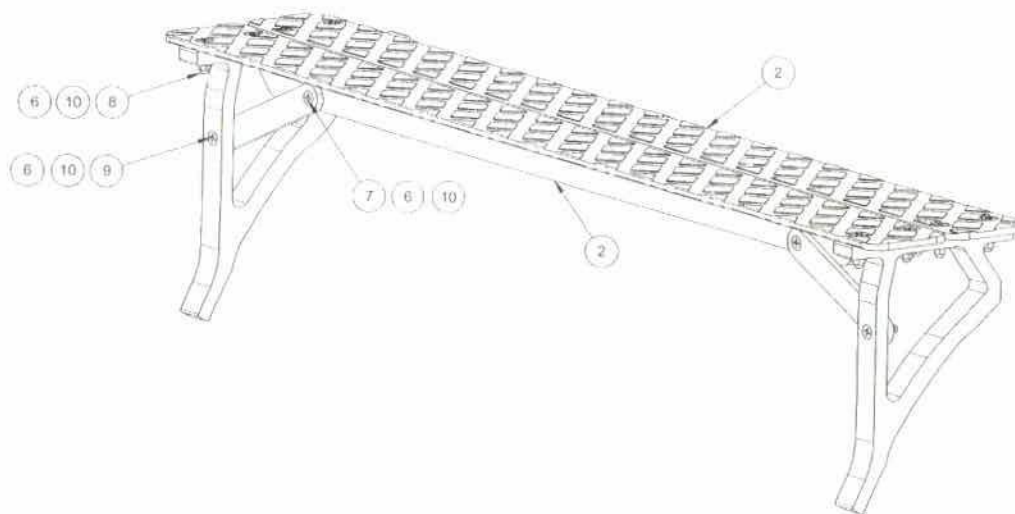
MAT007

144.8438

8323

144.8438

26.4 2012/02/04



D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042LJ	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

77852 H-LJ

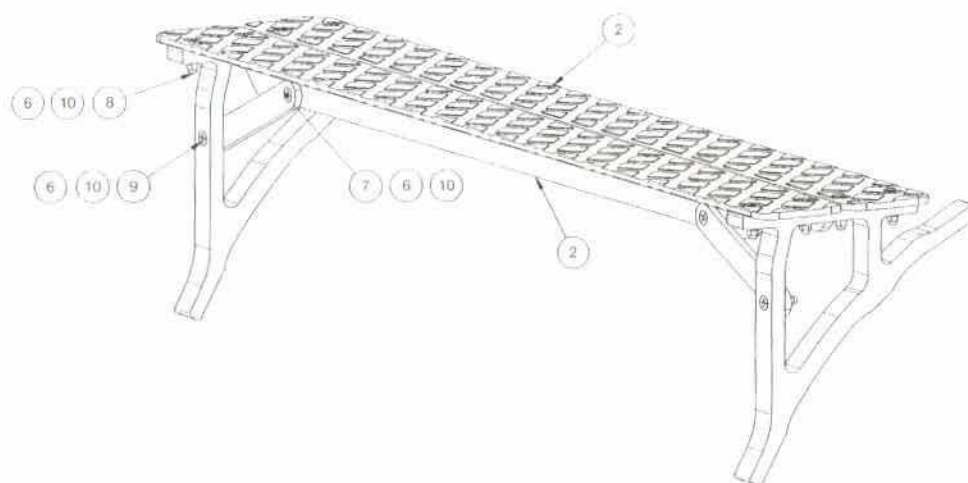
11/12/22

RELEASED  
2011-09-22

II	REDRAWN, LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE AND IS NOT TO BE RELEASED WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

7A852

ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY

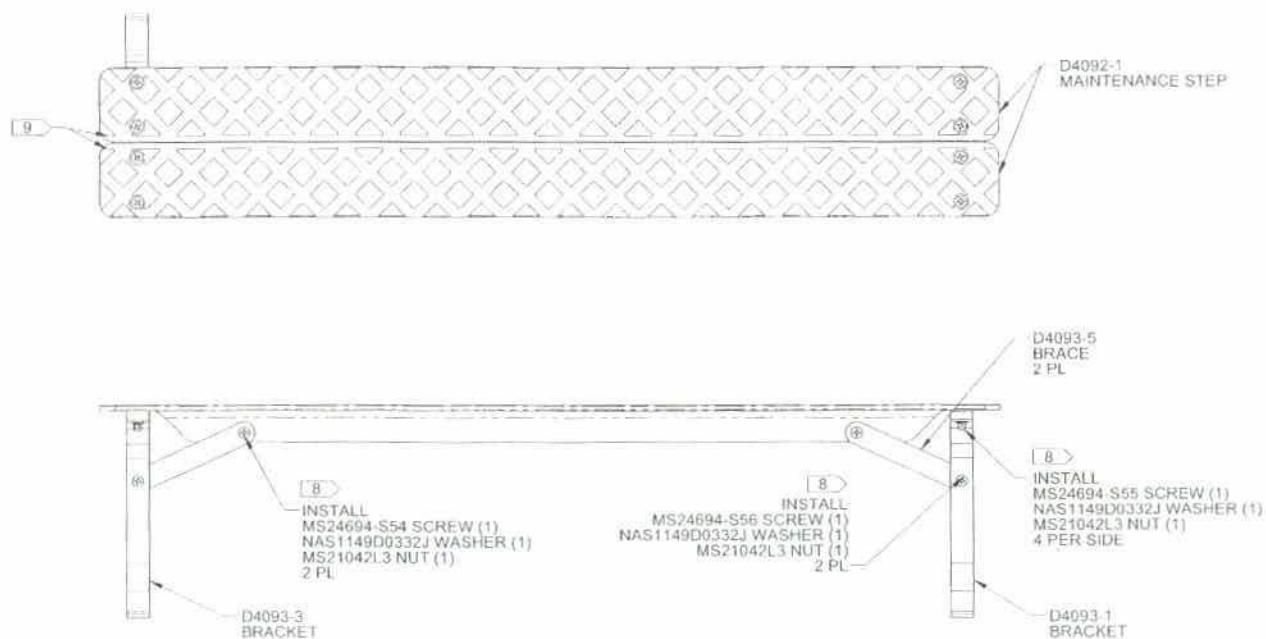


RELEASED  
2011-09-22  
JW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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77052



D4092-041 MAINTENANCE STEP ASSEMBLY

**NOTES:**

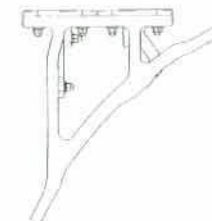
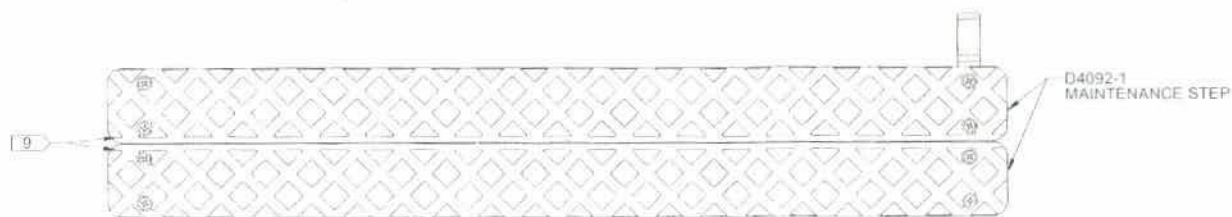
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED  
2011-09-22

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 3 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. 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3877, 3878, 3879, 3880, 3881, 3882, 3883, 3884, 3885, 3886, 3887, 3888, 3889, 3890, 3891, 3892, 3893, 3894, 3895, 3896, 3897, 3898, 3899, 3900, 3901, 3902, 3903, 3904, 3905, 3906, 3907, 3908, 3909, 3910, 3911, 3912, 3913, 3914, 3915, 3916, 3917, 3918, 3919, 3920, 3921, 3922, 3923, 3924, 3925, 3926, 3927</small>	



77052



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2011-09-22

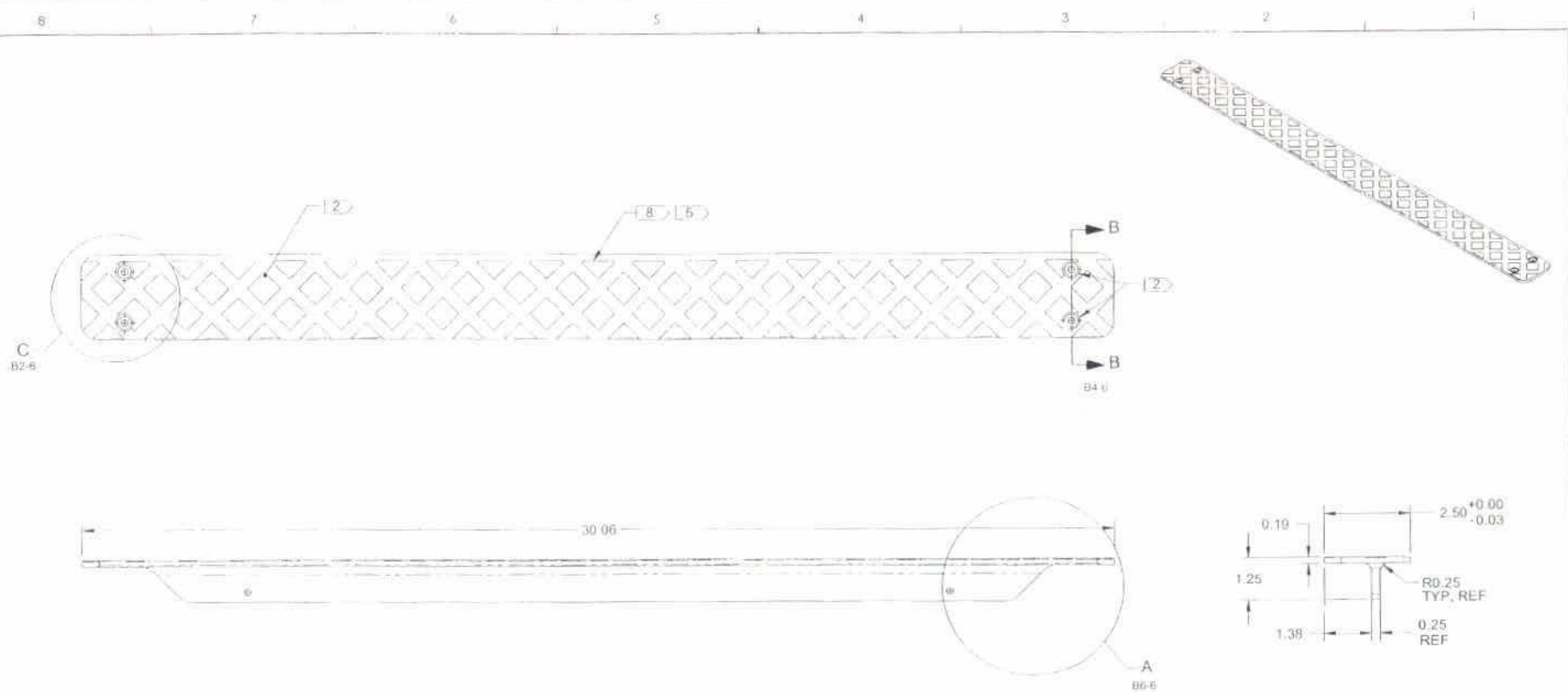
# D4092-042 MAINTENANCE STEP ASSEMBLY

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6 1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 4 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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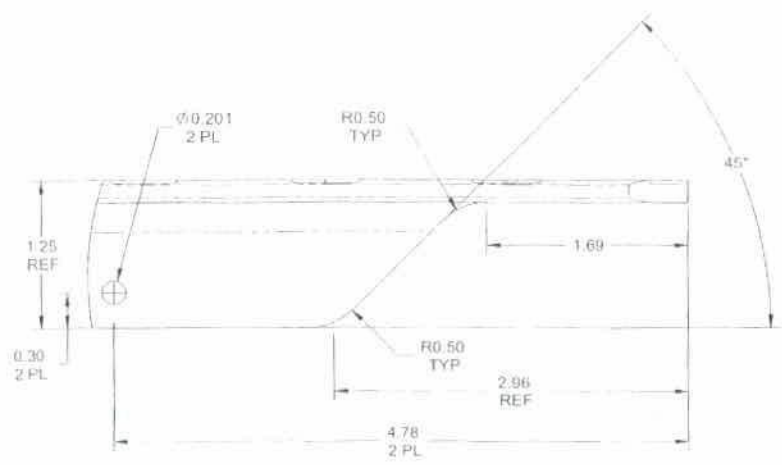
**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

- NOTES:
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.97 lbs
  - 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

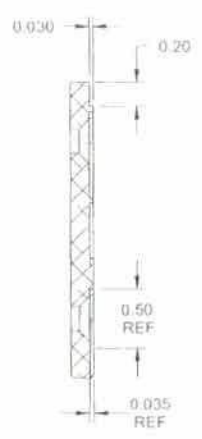
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2011-09-22

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DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 5 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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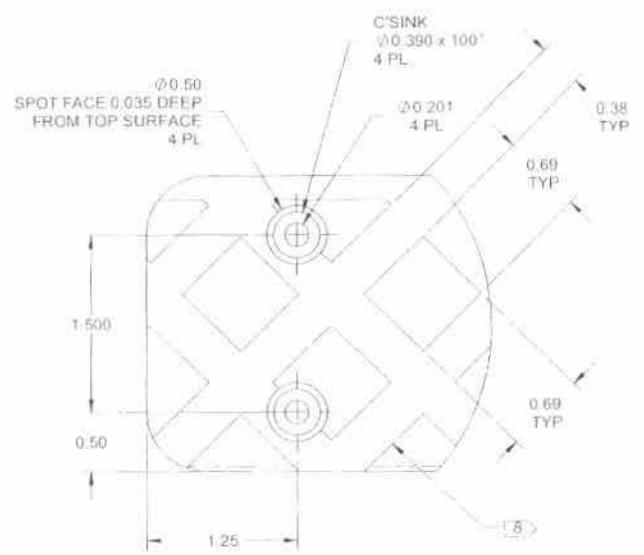
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DETAIL A  
SCALE 3X, TYP  
H3-5



SECTION B-B  
SCALE 3X, TYP  
C3-5



DETAIL C  
SCALE 3X, TYP  
C8-5

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2011-09-22

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DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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FIRST ARTICLE INSPECTION CHECKLIST

Section CWC 4012	Age 1 of 1
Description: M...	Part Number: 1000
Work Order: 1000000	